

Work Order ID 118953

118953

February-04-15 9:17:38 AM

Page 1

Item ID: D4012-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cushion
 Start Date: 5/09/14 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 5/09/14 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-05-09 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4012	B								

100		0.00							
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100
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Mill as per folio FA889
 Folio rev: N/A
 Dwg. rev: B

12 0 J.C.L. / 15/01/04 **DAS 08 9-89**

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC
 Quality Control
 Memo

12 0 J.C.L. / 15/01/04 **DAS 08 9-89**

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Item ID: D4012-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cushion

Start Date: 5/09/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/09/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: **S1545**

0.00

130

Packaging

Memo

0.00

Packaging

12**FEB 05 2015****DAS
06
6-69**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 15 02 -06**15-25**

Picklist Print

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Parent Item: D4012-1

D4012-1

Parent Item Name: Cushion

Start Date: 5/09/14

Required Date: 5/09/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP RevA: New issue 09.10.28 DD verified by:JLM
 revA as per dwg 09.11.18 DD verified by:JLM
 as per dwg Rev.B DD verified by:JLM

IPP RevB:
 IPP Rev:C 11.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	12.1500	0.37	5			
D4287-3									**				
Uhmw U-Channel													

DAS

08

9-89

J.C.-L 15/01/04

Location

Loc Qty

Loc Code

ST479a

12.15

121391

2.9

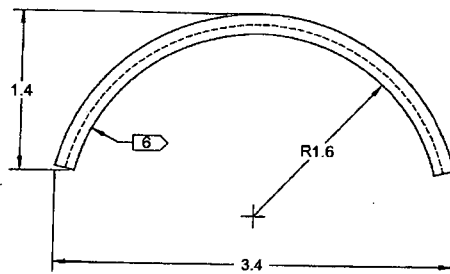
122488

9.25

6.457

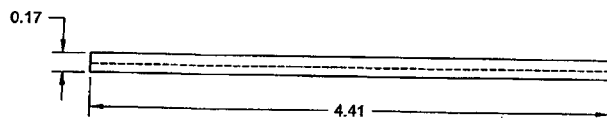
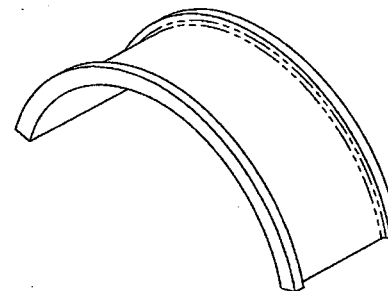
2.9

3.857

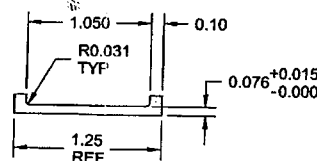


D4012-1 CUSHION
(MAKE FROM D4012-1F)

SHOP COPY
REFERENCE TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO DOCUMENT
VERSION NUMBER
NO. 118953 MLJ
~~150306~~
14-05-09



D4012-1F FLAT MACHINED STATE



RELEASED
2010-12-23
JMB

NOTES:

- 1) MATERIAL: MAKE FROM D4287-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4012

REV. B
SHEET 1 OF 1

TITLE
CUSHION

SCALE
NTS

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